

Work Order ID 86368

June-27-12 3:48:31 PM

86368

Page 1

Item ID: D2621

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Latch Plate, 350 Spacepod

Start Date: 27/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/28 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2621

Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2621 Dwg Rev: B Prog Rev: B 2-
Deburr if necessary

5052 .040

12 0 Jm 12-7-7

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

12 0 Jm 12-7-7

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

8/12/10/12

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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12

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

12. 12.79

140

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

140

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

W121279

3200F

3:20

3:50

12X 12/07/10

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

12 12.7.10

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12

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 13

0.00

160

Packaging

Memo

0.00

Packaging

12 12/7/11 sp

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

CK 12/7/12

12/7/11
1207-11

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Picklist Print

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Work Order ID: 86368

86368

Parent Item: D2621

D2621

Parent Item Name: Latch Plate, 350 Spacepod

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: C02.02.28Added inspection level 8 and level 5 SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M5052H32S.040 Purchased

No

110

sf

104.6400

0.0625

0.789474

M5052H32S 040

**

5052-H32.040 Sheet

Jm 12-7-7

Location

Loc Qty

Loc Code

MAT022

104.64

117130

4.4

118641

64

119384

23

121192

13.24

122321

122321

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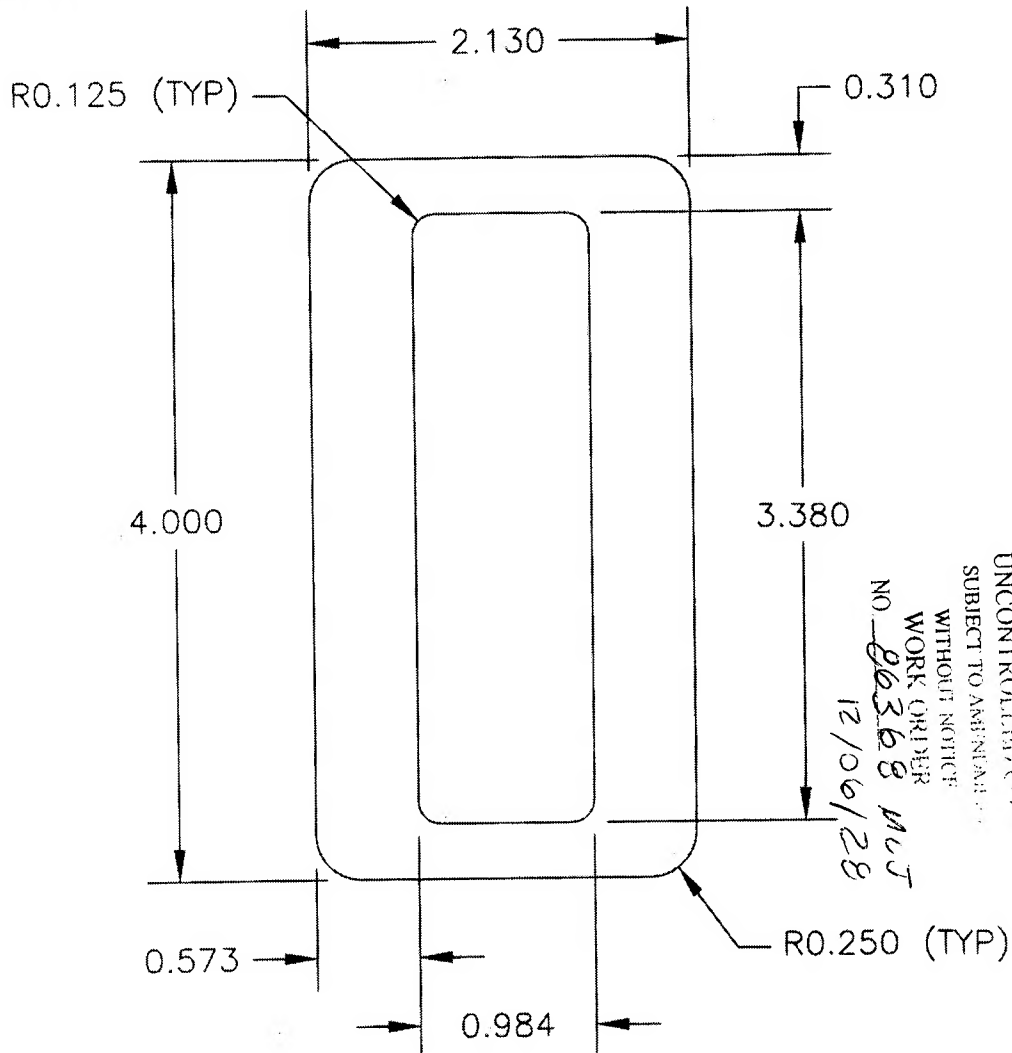
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DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2621	REV. B SHEET 1 OF 1
DATE 00.06.01		TITLE LATCH PLATE	SCALE 1:1
A	96.08.15	NEW ISSUE	
B	00.06.01	ADDED FINISH; R0.125 WAS R0.118	

RELEASED
00.06.05 *[Signature]*



MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11) OR 2024-T3
(QQ-A-250/4) 0.040 THICK
FINISH: CHEMICAL CONVERSION COAT PER DART 005 4.1
POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd

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